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D5404-2
Job Sheet 181273



Part No: D5404-2

Job Qty: 6 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEETS 3,4 IPP REV:A 16.03.23 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		SC 18/08/18
100	Waterjet	6 pcs	8/31/18	8/31/18	0.00	2.21	Waterjet1		SC 18/08/18
110	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Waterjet-4		SC 18/08/18
120	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC8-6		SEP 06 2018 68
130	Brake NC	6 pcs	8/31/18	8/31/18	0.07	0.25	Brake NC 1		9DAS
140	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC5		OCT 05 2018 68
150	Packaging	6 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3		9-89
160	QC21-SA	6 Ea	8/31/18	8/31/18	0.00	0.00	QC21		D46 21 3-89 OCT 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	24.9000 sf (4.15 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	25	289	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Package ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Container No: S107578 Part: D5404-2 Job No: 181273 Serial No/Batch: S107578 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/02/18			
Description Work Order Deviat							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		ROOT CATEGORY Pressure/Fc ☐ Bending ☐ Centre Not ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐					
OTHER : _____		Completed By _____ and / Supervisor _____ Approval Verification _____ IA Coordinator _____ Approval _____					

DART AEROSPACE LTD		Work Order:	181273
Description: Plate		Part Number:	125404-2
Inspection Dwg: 125404	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,13	+/- 0,030	0,132	1		USE -01	
0,50	+/- 0,030	0,504	1		TYPE	
1,00	+/- 0,030	1,012	1			
0,75	+/- 0,030	0,754	1			
0,75	+/- 0,030	0,753	1			
2,70	+/- 0,030	2,708	1			
0,78	+/- 0,030	0,785	1			
91,56	+/- 0,030	91,56	1			
90,55	+/- 0,030	90,55	1			
83,00	+/- 0,030	83,00	1			
77,75	+/- 0,030	77,75	1			
72,75	+/- 0,030	72,75	1			
68,25	+/- 0,030	68,25	1			
67,00	+/- 0,030	67,00	1			
65,55	+/- 0,030	65,55	1			
64,74	+/- 0,030	64,74	1			
63,93	+/- 0,030	63,93	1			
2,20	+/- 0,030	2,207	1			
1,48	+/- 0,030	1,488	1			
0,625	+/- 0,008	0,626	1			
0,516	+/- 0,008	0,517	1			
5,223	+/- 0,010	5,227	1			
6,32	+/- 0,030	6,325	1			
55,75	+/- 0,030	55,75	1			
52,50	+/- 0,030	52,50	1			
48,50	+/- 0,030	48,50	1			
44,50	+/- 0,030	44,50	1			
39,50	+/- 0,030	39,50	1			
35,50	+/- 0,030	35,50	1			

Measured by: SC	Checked by: DAS 68	QC Inspector: DAS 68
Date: 18/09/02	Date: 9-89	Date: SEP 08 2018

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

